

Work Order ID 139999

December 16, 2015 11:56:40 AM

139999

Page 1

Item ID: E4752-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spacer
 Start Date: 12/16/2015 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 3/1/2016 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: Sid Date: 11/12/17 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
E4752	A

100	FLOW WATER JET	0.00				6	0		DAS 40
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100
 Hardinge Memo 0.00
 Hardinge CNC Lathe Small 1-Cut as per Dwg E4752 AND FOLIO FB
 Dwg Rev: A

Prog Rev: A+
 2-Deburr as required

QC2- Inspect parts off machine FAI/FAIB 0.00

110
 QC Memo 0.00
 Quality Control

110	QC2- Inspect parts off machine FAI/FAIB	0.00				6	0		DAS 40
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110
 QC Memo 0.00
 Quality Control

QC2- Inspect parts off machine FAI/FAIB 0.00

110
 QC Memo 0.00
 Quality Control

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00				6	0		DAS 14 9-89 16/02/22
120 QC Quality Control	Memo	0.00							
160	Chemical Conversion Coat per QSI005 4.1	0.00				6	0		6 of 16/02/22
160 HandFinish Hand Finishing	Memo	0.00							
161	QC7-Inspect Chemical Conversion Coat	0.00				6			DAS 38 9-89 FEB 25 2016
161 QC Quality Control	Memo	0.00							

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 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>St</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

MCJ FEB 26 2016

Picklist Print

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Work Order ID: 139999

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Parent Item: E4752-3

F4752-3

Parent Item Name: Spacer

Start Date: 12/16/2015

Required Date: 3/1/2016

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 14-01-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R1.500		Purchased			No		f	19.9050		0.157895			DAS
M6061T6R1 500									**			16/02/18	40
6061-T6 Round Bar 1.50													9-89

Location

Loc Qty

Loc Code

MAT012

19.905



m131226

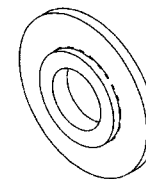
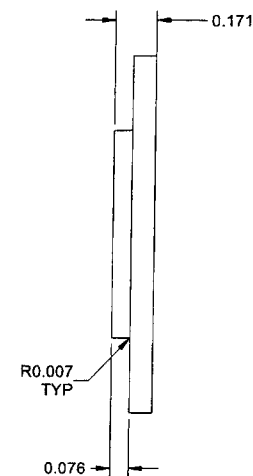
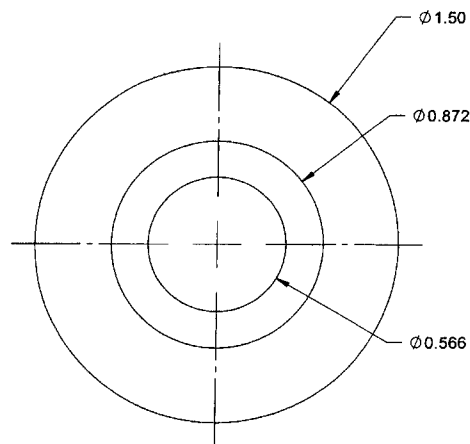
24.5

7.905

m133828

12

0.188



E4752-3 SPACER

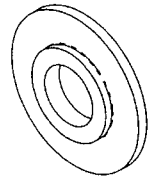
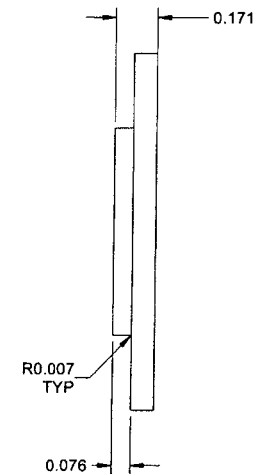
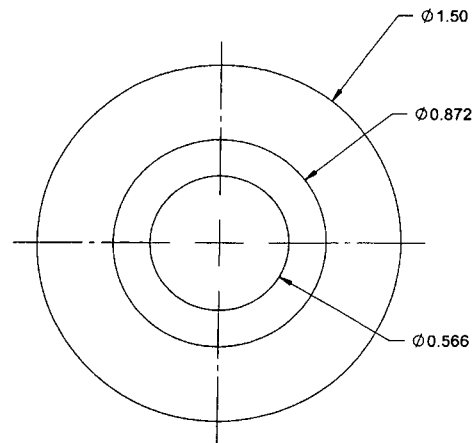
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6511/T62 ALUMINUM ROUND BAR
 QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
 OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
 OR ASTM B211 OR ASTM B221
 REF: DART SPEC. M6061T6R1.500
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs

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20151217
 SW 1399999

2013-11-23



E4752-3 SPACER

RELEASED
2013-11-23

NOTES:

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QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
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